

Work Order ID 135980

August 26, 2015 2:33:57 PM

135980

Page 1

Item ID: D206-642-313

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Stop *NS2*

Start Date: 8/26/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/2/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SA Date: 20150826 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	0.00							
100	DOCUMENT CONTROL								DAS 02 9-89
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-313	CHG001							SEP 16 2015
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							DAS 02 9-89
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									DAS 02 9-89
QC	Memo	0.00							
Quality Control									SEP 16 2015

B13599041

Ship Sept 11/15

MCS 1509-03

SEP 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																																
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				QC / QA Coordinator Approval																																																																
Root Cause		FAULT CATEGORY																																																																		
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OTHER : _____																																																																				

Work Order ID 135980***135980***

Page 2

Item ID: D206-642-313

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Stop

NS2

Start Date: 8/26/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/2/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-313								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
02
9-89

SEP 16 2015

SEP 18 2015

SH 20150917

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

August 26, 2015 2:34:34 PM

Page 1

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.18 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-351		Manufactured	No			110	Each	0.0000	1	1	27 9-89		
D206-642-351		DAS 02							**				DAS 6 9-89
Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH													
D206-648-013		Manufactured	No			110	Each	7.0000	1	1	27 9-89		
D206-648-013		DAS 02							**				DAS 6 9-89
Ground Handling Wheel Modification													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PKG013		7							
				132687		3							
				132688		4							
D2932-1		Manufactured	No			110	Each	7.0000	1	1	27 9-89		
D2932-1		DAS 02							**				DAS 6 9-89
Saddle LH Out, 206													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST396		6							
				114490		1							
				129140		2							
				132459		3							
				ST403		1							
				125650		1							

SEP 02 2015

Picklist Print

August 26, 2015 2:34:34 PM

Page 2

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D2933-1

Manufactured No

110

Each

7.0000

1

1

D2933-1

DAS
02
9-89

Saddle LH In, 206

**

DAS

27

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

ST389

3

114491

1

129142

2

ST396

3

133503

3

ST403

1

126664

1

D2938-1

Manufactured No

110

Each

7.0000

1

1

D2938-1

DAS
02
9-89

Saddle LH Out, 206

**

DAS

27

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

ST390

3

114492

1

129144

2

ST395

3

133510

3

ST403

1

125652

1

SEP 02 2015

Picklist Print

August 26, 2015 2:34:34 PM

Page 3

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D2939-1

Manufactured No

110

Each

6.0000

1

1

D2939-1

Saddle LH In, 206

DAS
02
9-89

Location

Loc Qty

Loc Code

ST391

3

129146

3

ST395

2

133404

2

ST403

1

125653

1

68-6
27
9-89

DAS
6
9-89

AN3-41A

Purchased No

110

Each

570.0000

8

8

AN3-41A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

20

122416

20

ST338a

550

123355

550

68-6
27
9-89

DAS
6
9-89

D2652

Manufactured No

110

Each

408.0000

16

16

D2652

Bushing

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

321

129993

17

134494

4

135573

300

ST012a

42

123711

32

124422

2

8905

8

68-6
27
9-89

DAS
6
9-89

SEP 02 2015

August 26, 2015 2:34:35 PM

Shop Packet Print

Page 3

Picklist Print

August 26, 2015 2:34:35 PM

Page 4

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,207.000

8

8

MS21042L3

Nut

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

237

M131317

237

ST305

586

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

19

M132930

485

NAS1149D0363J

Purchased

No

110

Each

1,857.000

8

8

NAS1149D0363J

Washer

DAS
02
9-89

DAS
27
9-89
SEP 02 2015

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

302

m130799

302

ST269

1309

m126319

7

m131618

1

m132317

108

~~m132677~~

193

m133031

1000

Picklist Print

August 26, 2015 2:34:35 PM

Page 5

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

84.0000

4

4

AN5-10A

DAS
02
9-89

BOLT

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

ST338

33

m132803

33

AN5-12A

Purchased

No

110

Each

62.0000

4

4

AN5-12A

DAS
02
9-89

Bolt

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST299A

25

M131957

25

ST338

37

M132189

37

AN5-11A

Purchased

No

110

Each

22.0000

8

8

AN5-11A

DAS
02
9-89

BOLT

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST299A

20

M126105

1

M132189

19

ST338

2

M132551

2

M13077

3

SEP 02 2015

Picklist Print

August 26, 2015 2:34:36 PM

Page 6

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,029.000

8

8

NAS1149D0563.J

Washer

**DAS
02
9-89**

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

801

m130799

63

m132035

55

m132256

83

m132677

600

ST269

156

m128257

156

ST271

19

m131026

19

AN4-6A

Purchased

No

110

Each

649.0000

12

12

AN4-6A

BOLT

**DAS
02
9-89**

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST345

506

M128403

8

M131153

498

SEP 02 2015

August 26, 2015 2:34:36 PM

Shop Packet Print

Page 6

Picklist Print

August 26, 2015 2:34:36 PM

Page 7

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Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

2,652.000

24

24

NAS1149D0463J

WASHER

DAS
27
9-89

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1611

M129682

86

M130799

371

M132035

1029

M132317

125

MS21042L4

Purchased

No

110

Each

2,508.000

12

12

MS21042L4

Locknut

DAS
02
9-89

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

124

m127813

124

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2212

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2032

SEP 02 2015

12

August 26, 2015 2:34:36 PM

Shop Packet Print

Page 7

Picklist Print

August 26, 2015 2:34:36 PM

Page 8

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

9.0000

1

1

D3407-043

Tow Ring

DAS
02

9-89

**

DAS

27

9-89

DAS

16

9-89

Location

Loc Qty

Loc Code

st530

9

132733

9

D3456-1

Manufactured No

110 Each

76.0000

1

1

D3456-1

Washer

DAS

02

9-89

**

DAS

27

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038A

66

134407

66

ST051A

3

128456

3

D3457-1

Manufactured No

110 Each

18.0000

2

2

D3457-1

Washer

DAS

02

9-89

**

DAS

27

9-89

DAS

27

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST040

8

127393

8

August 26, 2015 2:34:37 PM

Shop Packet Print

Page 8

Picklist Print

August 26, 2015 2:34:37 PM

Page 9

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,004.000

1

1

MS21043-4

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	187	
m128798	187	
ST273A	300	
m132803	300	
ST304	477	
m128818	39	
m131697	9	
m132382	4	
m132536	125	
m133031	300	

**

DAS
27
9-89

DAS
6
9-89

AN4C5A

Purchased

No

110

Each

24.0000

1

1

AN4C5A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001	5	
131677	5	
ST345	19	
m132857	19	

**

DAS
27
9-89

NAS1149C0463R

Purchased

No

110

Each

234.0000

1

1

NAS1149C0463R

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001	77	
m127306	77	
ST271	157	
m128401	157	

**

DAS
27
9-89

DAS
6
9-89

SEP 02 2015

August 26, 2015 2:34:37 PM

Shop Packet Print

Page 9

Picklist Print

August 26, 2015 2:34:37 PM

Page 10

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110

Each

10.0000

1

1

D3413-1

O-Ring

DAS
02
9-89

**

Location

Loc Qty

Loc Code

st530

10

125157

3

129085

1

132500

1

133922

5

DAS
27
9-89

DAS
6
9-89

D2712

Manufactured No

110

Each

135.0000

10

10

D2712

Set Screw

DAS
02
9-89

**

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

10

89929

10

ST012a

70

130024

70

DAS
27
9-89

DAS
6
9-89

D2934

Manufactured No

110

Each

15.0000

2

2

D2934

Saddle Spacer

**

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

9

132439

9

DAS
27
9-89

DAS
6
9-89
SEP 02 2015

Picklist Print

August 26, 2015 2:34:37 PM

Page 11

Work Order ID: 135980

135980

Parent Item: D206-642-313

D206-642-313

Parent Item Name: Skidtube LH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

10.0000

2

2

D2935

Saddle Spacer

136244

**DAS
02
9-89**

Location

Loc Qty

Loc Code

**DAS
27
9-89**

FG

6

31793

6

ST014

2

115157

2

ST025A

2

131107

2

August 26, 2015 2:34:37 PM

Shop Packet Print

Page 11

**DAS
6
9-89**

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12

DART AEROSPACE USA, INC.**IIN-D206-642**

Page 30 of 43

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN980C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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